Work Order ID 53712- | w Split Page 1 November 13, 2009 9:56:05 AM D3594-043 Accept Setup Start Item ID: Revision ID: B Stop Floor Doubler Assembly, LH Item Name: 13/11/2009 Start Qty: 100 Start Date: Cust Item ID: Req'd Qiy: 7.00 Required Date: 20/11/2009 Customer: Reference: Start Run Date: 19-1/-Process Plan: Tooling: Date: Approvals: Stop SPC (Y/N): Date: OC: Date: Reject Reject Insp. Set Up/ Draw Draw Plan Accept Sequence ID/ Operation Code Qty Qty Number Stamp Rev. Number Description Run Hours Work Center ID Revision Nbr Draw Nbr D3594 Rev B 0.00 100 B 411-8 FLOW WATER JET Waterjet 1-Cut as per Dwg D3594 Dwg Rev: FLOW CNC Waterjet Deburr if necessary 6061 QC2- Inspect parts off machine FAI/FAIB 0.00 110 129-11-18 0.00 Memo Quality Control OC8- Inspect parts - second check 120 2) 802/4/18 Memo Quality Control

Dart Ae	rospace Lt	d						
W/O:			WC	RK ORDER CHANGES	3			
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
								-
	2							
Part No				gory:				
NCR:	nesc			ER NON-CONFORMAN			Date: _	
		December 410		Corrective Action Section I	В			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Approval Chief Eng	Approva QC Inspect
- x								
							P.	
							-	

### Work Order ID 53712



Page 2

November 13, 2009 9:56:05 AM

Item ID:

D3594-043

Revision ID: B

Item Name:

Floor Doubler Assembly, LH

Start Date:

13/11/2009

Start Qty: 7.00 Req'd Qty: 7.06

Required Date: 20/11/2009

Accept

Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start



OC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Memo

C'SINK AS PER DWG D3594

Set Up/ Run Hours

0.00

0.00

Draw Number

Draw Rev.

Plan Accept Code Qty

Reject Qty

Run

Reject Number

Insp. Stamp

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

=> Sorlulzz

150

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

mp 09/4/30

81

HandFinish

Memo

Hand Finishing

Dart Aerospace Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	()	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
_						-			
		1							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es N	o DQA:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C	Clos	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)			
DATE	STEP	Description of NC	-	Corrective Action Secti			Verification	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector

### Work Order ID 53712



Page 3

November 13, 2009 9:56:05 AM

Item ID:

D3594-043

B

Revision ID: Item Name:

Floor Doubler Assembly, LH

Start Date:

13/11/2009

Start Qty: 7.00

Req'd Qty: 7.00

Required Date: 20/11/2009

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Draw

Number

Run

Reject

Qty

Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Plan

Code

Insp.

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

Draw

Rev.

Qty

Accept

Reject Number

Stamp

170

Small Fab Small Fab

Small Fab

Memo

Memo

Install Nut Plates As per Dwg D3594

0.00

0.00

180

Quality Control

QC5- Inspect part completeness to step on W/O

=> Scolul13

-043

# **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHA	NGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										16.9
		8 9		7						Brit.
										7.22
										528
Part No		PAR #:	Fault Cat	legory:	NCF	R: Yes I	No DQ	A:	Date:	
	Res	solution:	Dispositi	on:	QA:	N/C Clo	sed:	_	Date:	
NCR:		,	WORK ORI	DER NON-CONFOR	RMANCE	(NCR	)			
DATE	STEP	Description of NC			Section B		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date	To Your And Address of the	on C	Chief Eng	QC Inspector

#### Work Order ID 53712



Page 4

November 13, 2009 9:56:05 AM

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	ter	11			
			*.	u	

D3594-043

Accept



Setup Start

Stop



Revision ID:

Floor Doubler Assembly, LH Item Name:

Start Date:

13/11/2009

Start Qty: 7.00

Req'd Qty: 7.00 Required Date: 20/11/2009



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



OC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop



Sequence ID/ Work Center ID

190

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

0.00

Draw Number Draw Plan Rev.

Accept Qty Code

Reject Qty

Reject Insp. Number

Stamp

Packaging

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

Dart Aerospace L	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								r roa mgr	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes N	lo DQA	A:	Date:	
		solution:							
NCR:		,	WORK ORI	DER NON-CONFORMA	ANCE (NCR)				
DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
							0		
							2		
						480			
								-	the contract of
						3			-
						57		1.34	- New

### **Picklist Print**

November 13, 2009 9:56:11 AM

Work Order ID: 53712

Parent Item:

D3594-043RevB

Parent Item Name: Floor Doubler Assembly, LH

Comments:



Start Date: 13/11/2009

Required Date: 20/11/2009

Page 1

Start Qty: 7.00

Required Qty: 7.00

B9-11-18

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty To Pick	Qty Issued	Issued	Status
1	MS20426AD4-4		Purchased	No		100	Each	3,000.000	14,0000	111/30	3/	(8)

111111				II
Rive	it:			

Warehouse	Lo	oc Qty	Loc Code	
Location				
Main Warehouse				
ST		3000		
15541		3000		
	170	sf	194.4599	3.7579

M6061T6S.080	Purchased

6061-T6 .080 Sheet

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	194.45987	
107904	0.02	
110254	1.5	
110630	38.0926	
112040	0.0437	
112141	9	

112512

112763

110630×1=7 0.2784 112763 X7 = 14. 145.52517

## **Dart Aerospace Ltd**

		1440		-				
		WC	ORK ORDER CHANG	ES				
STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			A grant		11			
	į.							
-								
								L
	1 1							
:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
Re	esolution:	Disposition	n:	_ QA: N/C (	closed:		_ Date: _	
	100	WORK ORDI	ER NON-CONFORM	ANCE (NC	R)			
CTED	Description of NC				Verification			Approval
SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		& Sect		Chief Eng	QC Inspector
-								-
	:	:PAR #: Resolution:  Description of NC	PAR #: Fault Cate  Resolution: Disposition  WORK ORD  STEP Description of NC Section A Initial	PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER NON-CONFORM  STEP Description of NC Section A Corrective Action Section A Corrective Action Description	STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes  Resolution: Disposition: QA: N/C C  WORK ORDER NON-CONFORMANCE (NC  STEP Description of NC	STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQ  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty  PAR #: Fault Category: NCR: Yes No DQA:  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  : PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC

#### **Picklist Print**

November 13, 2009 9:56:11 AM

Work Order ID: 53712

D3594-043RevB Parent Item:

Parent Item Name: Floor Doubler Assembly, LH

Comments:



Start Date: 13/11/2009

Required Date: 20/11/2009

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	k	Route Seq ID			Remaining Qty To Pick		Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	---	-----------------	--	--	--------------------------	--	----------------	--------

MS21069-5

Purchased

No

170 Each

20.0000

7.0000

Page 2

Anchor nuts

Loc Qty Loc Code Warehouse Location Main Warehouse ST 20 20 111310

M113627 (5x

Dart Aerosp	ace Ltd
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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		100						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:	Date: _	
NCR:		li .	WORK ORD	ER NON-CONFORMA	ANCE (NCR	)		
DATE	CTED	Description of NC		NEW CONTRACTOR OF THE PROPERTY	ion B	Verification	Approval Chief Eng	Approval QC Inspector
DATE	SIEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		
		-						

DART AEROSPACE LTD	Work Order:	53717
Description: Floor Doubler, LH	Part Number:	D3594-3
Inspection Dwg: D3594 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

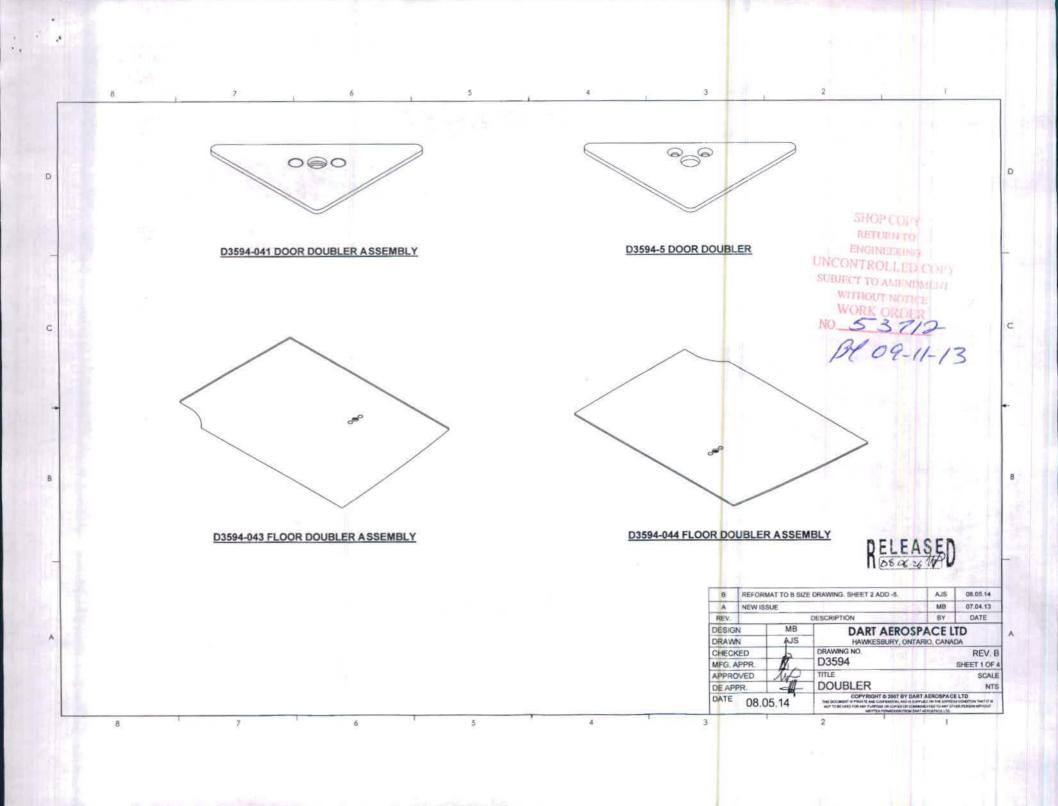
X First Article Prototype

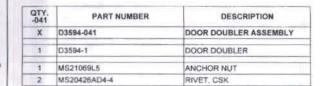
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.25	+/-0.030	12,25	*			12 17 5
7.85	+/-0.030	7.845	X		= 7:34	
7.313	+/-0.010	7.313	×			
2.688	+/-0.010	2.687	女			
Ø0.323	+0.006/-0.001	.394	K			
Ø0.128	+0.005/-0.001	,130	\$			
0.359	+/-0.010	, 354	A			
0.718	+/-0.010	IET.	₫.			
0.81	+/-0.030		×			F-01052
2.32	+/-0.030	2,337	K			31111
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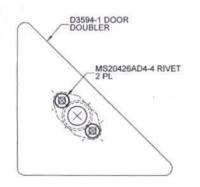
Measured by:	B	Audited by:	Prototype Approval:	N/A
Date:	9-11-18	Date: Offule	Date:	N/A

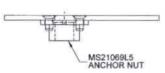
Rev	Date	Change	Revised by Approve
Α	07.07.18	New Issue P/O D3594-043	KJ/JLM
В	08.09.04	Dwg Rev updated	KJ/DD 10 AL
C	09.05.07	Dimensions updated per Dwg Rev B	KJ/EC CX





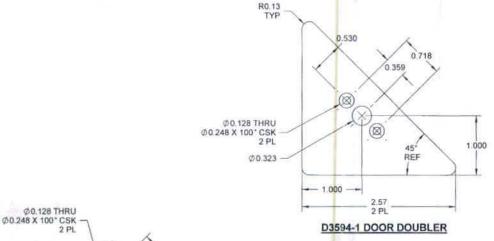


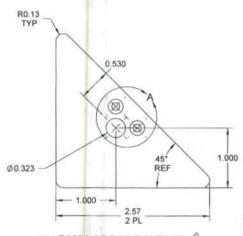




#### (4) D3594-041 DOOR DOUBLER ASSEMBLY

NOTES: 1) MATERIAL: -1 & -5 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF, DART SPEC, M6061TRS.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-6" USING FINE POINT PERMANENT INK MARKER
5) IDENTIFY WITH DART P/N "D3594-6" USING FINE POINT PERMANENT INK MARKER
6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs





5 D3594-5 DOOR DOUBLER B

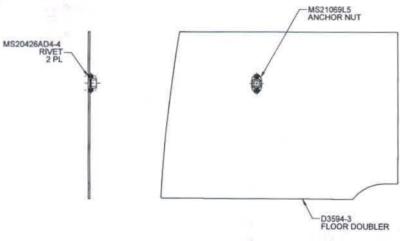
DESIGN MB		DART AEROSPACE LTD				
DRAWN	AUS	HAWKESBURY, ONT	ARIO, CANADA			
CHECKED	5.	DRAWING NO.	REV. B			
MEG. APPR.	20	D3594	SHEET 2 OF 4			
APPROVED	Svelo	TITLE	SCALE			
DE APPR.	-14_	DOUBLER	NTS			
DATE 08.0	5.14	COPYRIGHT & 2007 BY DART AEROSPACE LTD				

REF

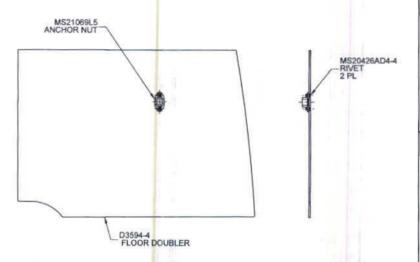
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QTY. -043 PART NUMBER DESCRIPTION D3594-043 FLOOR DOUBLER ASSEMBLY, LH D3594-044 FLOOR DOUBLER ASSEMBLY, RH D3594-3 FLOOR DOUBLER LH FLOOR DOUBLER, RH D3594-4 MS21069L5 ANCHOR NUT MS20426AD4-4 RIVET CSK



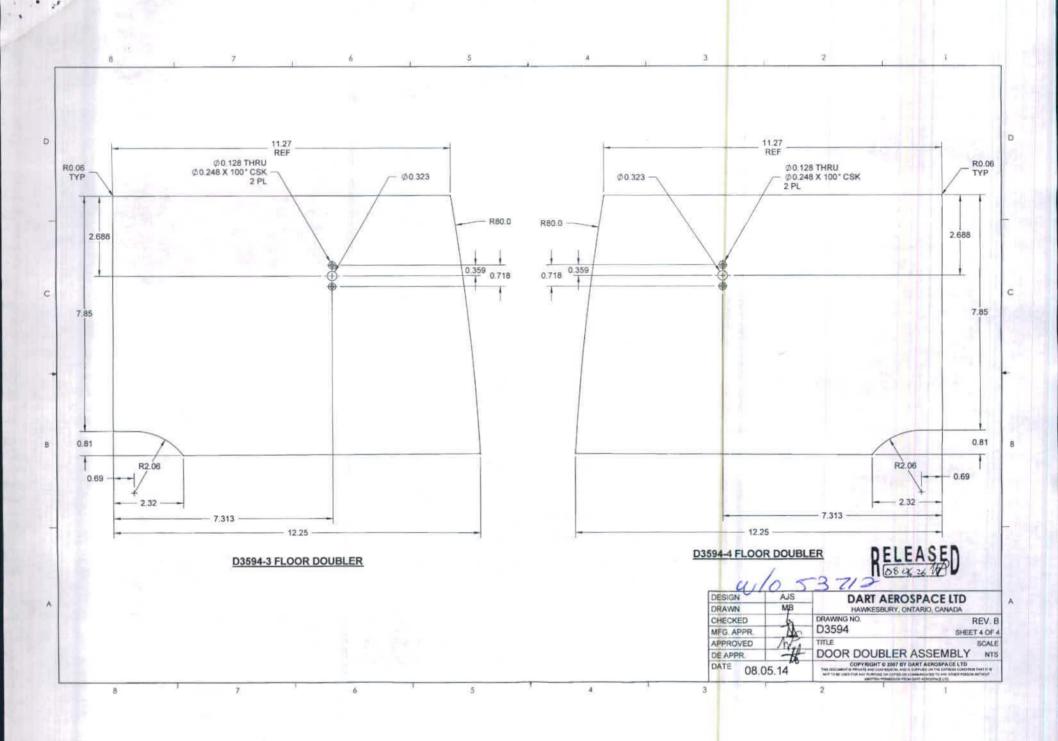
#### D3594-043 FLOOR DOUBLER ASSEMBLY



#### D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:
1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHÉMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART PIN "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -043 & -044: 0.80 lbs

DESIGN MB DART AEROSPACE LTD DRAWN AJSI HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3594 MFG. APPR. SHEET 3 OF 4 TITLE APPROVED SCALE DOUBLER DE APPR COPYRIGHT 6 2007 BY CART AEROSPACE LTD DATE 08.05.14



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